

Work Order ID 76770

76770

Page 1

Monday, November 21, 2011 10:57:08 AM

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00				8	0		
-----	--------------------------------	------	--	--	--	---	---	--	--

100
 HAAS 1
 HAAS CNC vertical machine #1

Memo
 Program part number and batch number.
 Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG
 DWG REV: 5
 FOLIO REV: 44

110	CONVENTIONAL MILLING MACHINE	0.00				8	0		
-----	------------------------------	------	--	--	--	---	---	--	--

110
 Mill Conv
 Conventional Milling Machine

Memo
 Machine Keyway and inspect per attached dimension sheet

11-12-16
20 11.12.17

20 11.12.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		24 11-12-17		8	8		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 11/12/19		8	8		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		AS 11-12-19		8	8		

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Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

150

Powdercoat
 Powder Coating

Memo

START TIME: 10:15
 OVEN TEMPERATURE: 320 °F
 FINISH TIME: 10:45

160	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

160

QC
 Quality Control

Memo

170	Identify as per dwg & Stock Location: ST 435	0.00							
-----	--	------	--	--	--	--	--	--	--

170

Packaging
 Packaging

Memo

8X M-11/12/20

8 BP 11-12-20

8X SP 11-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 76770***76770***

Page 4

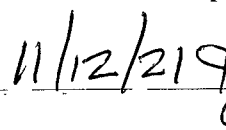
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/21 
MK
11-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 10:57:13 AM

Page 1

Work Order ID: 76770

76770

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.06.22Removed P/O for powder coatEC
IPP Rev:D As per Rev D 07-03-19 JLM IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bn Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	152.0000	1	8			
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D6101-001

Saddle Billet

**

20 11-12-5

Location

Loc Qty

Loc Code

MAT040

152

66965

1

69677

2

73774

60

74648

21

74679

68

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	76778
Description: 206 Saddle, Inboard, Left side	Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.121	.121		
B	0.100	0.140		.134	.133	.134	.133		
C	1.125	1.145		1.135	1.135	1.136	1.135		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.249	.249	.248	.249		
F	1.313	1.343		1.324	1.323	1.323	1.323		
G	0.210	0.230		.219	.219	.219	.219		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.576	1.575		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.110	.111	.111	.111		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.999	5.999	5.999	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.796	.796	.797	.797		
W	0.540	0.560		.551	.551	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.921	.921	.921	.922		
AA	0.490	0.510		.499	.500	.499	.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL	28
Date:	11-12-16	11.12.17

Audited by:	h e
Date:	11/12/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76770
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

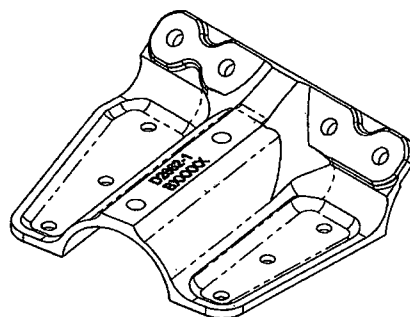
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I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
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V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.550	.550	.550	.550		
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Z	0.912	0.932		.921	.921	.921	.921		
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AB	0.178	0.198		.188	.188	.188	.188		
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AD									
AE									
AF									
Accept/Reject									

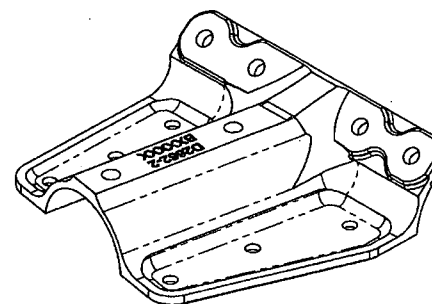
Measured by: SL 29
Date: 11-12-16 11.12.17

Audited by: K.A
Date: 11/12/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76770

R11-11-21

RELEASED
2011-11-16
MT

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 0122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25

DESIGN	<i>JP</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	KENT, WA	
CHECKED	<i>A.S.</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JP</i>	D2662	SHEET 1 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

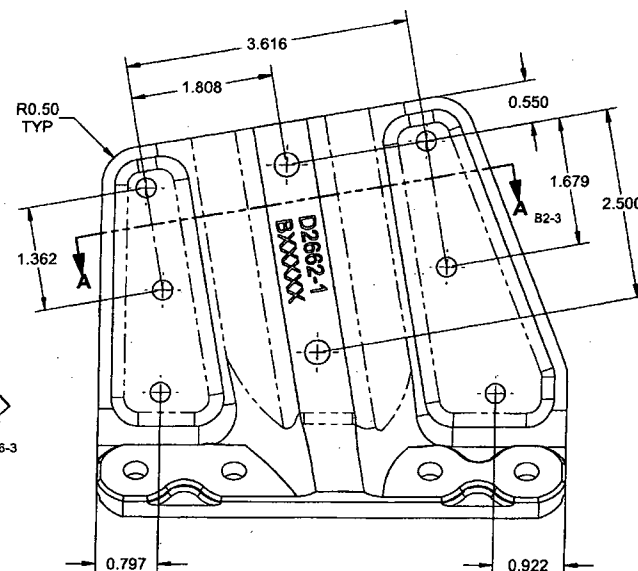
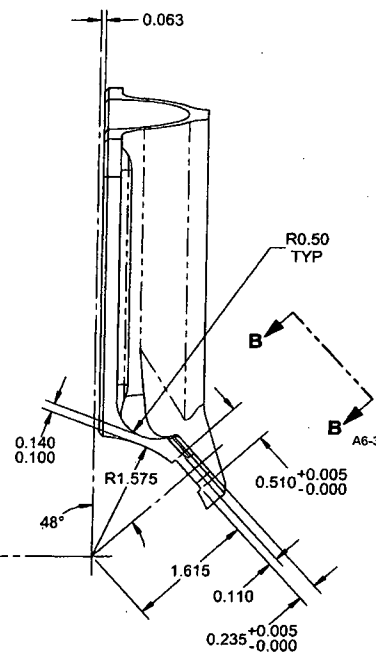
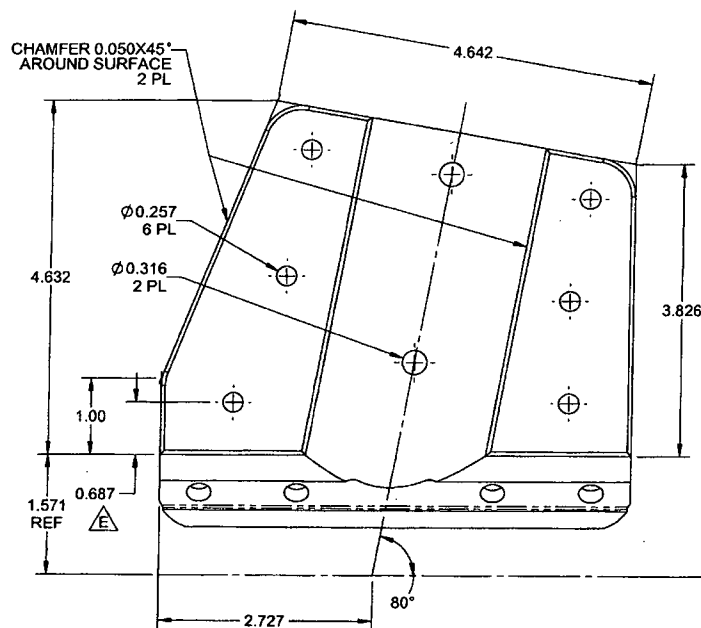
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D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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RELEASED
2011-11-16

76770

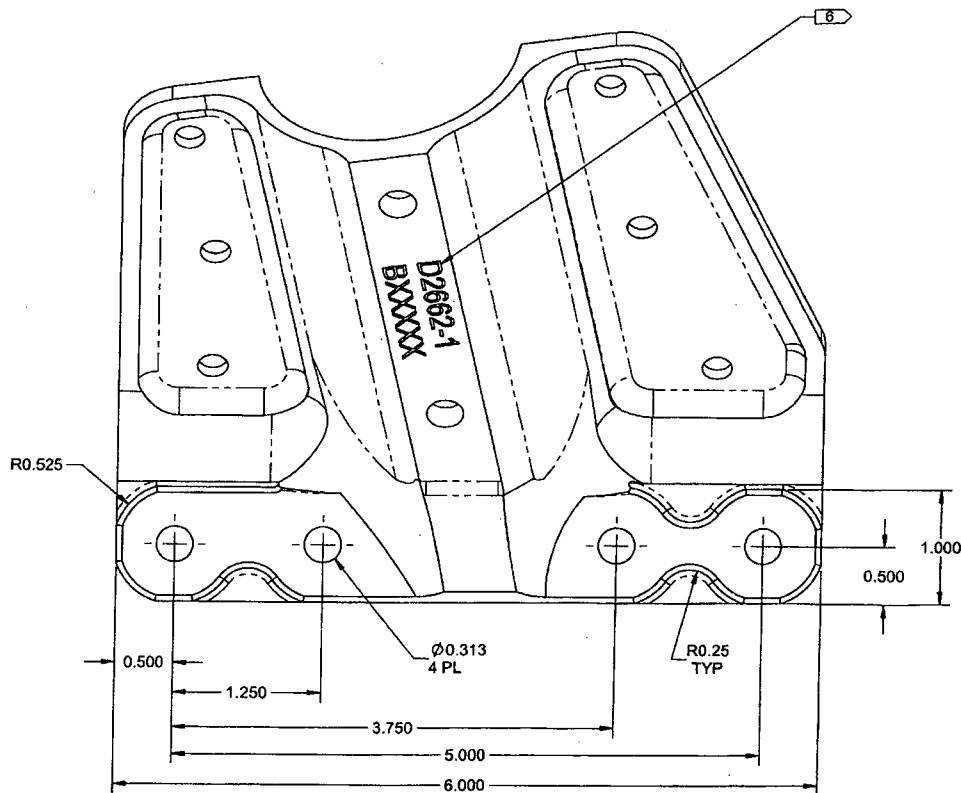
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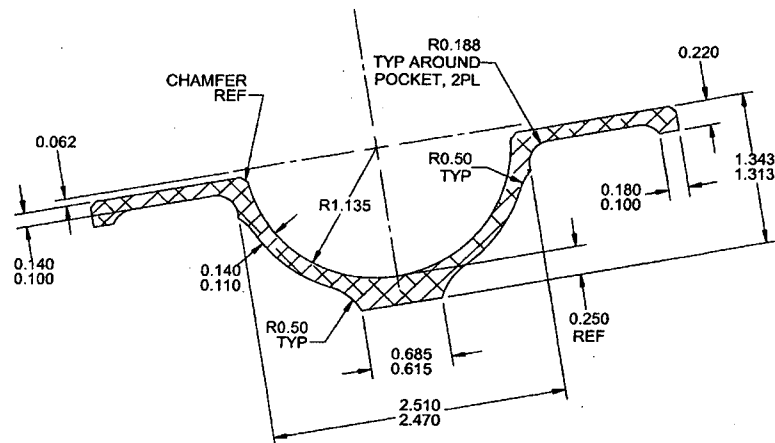
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VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C1-2

RELEASED
2011-11-16

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2662	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

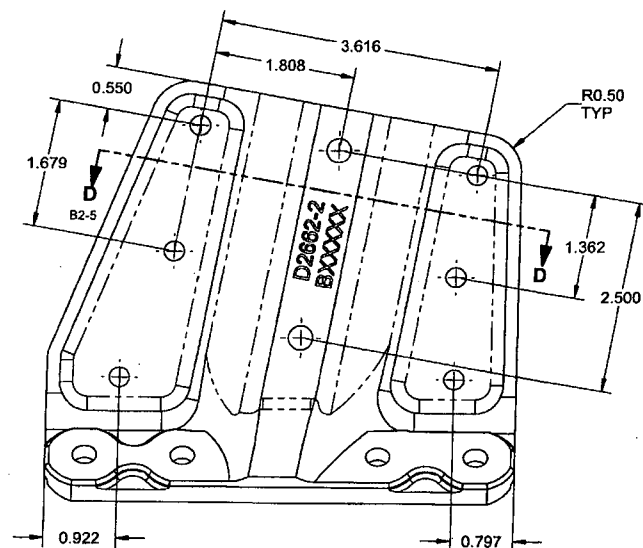
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1) MATERIAL: 7075-T351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAX. THK FROM D6101-001 SADDLE BILLET

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010

7) WEIGHT: 0.66 lbs

RELEASE
2011-11-16

DESIGN	<i>JS</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE KEPT UNDER LOCK AND KEY AND NOT BE LOANED, REPRODUCED, COPIED, OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	<i>JS</i>		SHEET 4 OF 5
CHECKED	<i>JS</i>		SCALE
MFG. APPR.	<i>JS</i>		NTS
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	11.10.31		

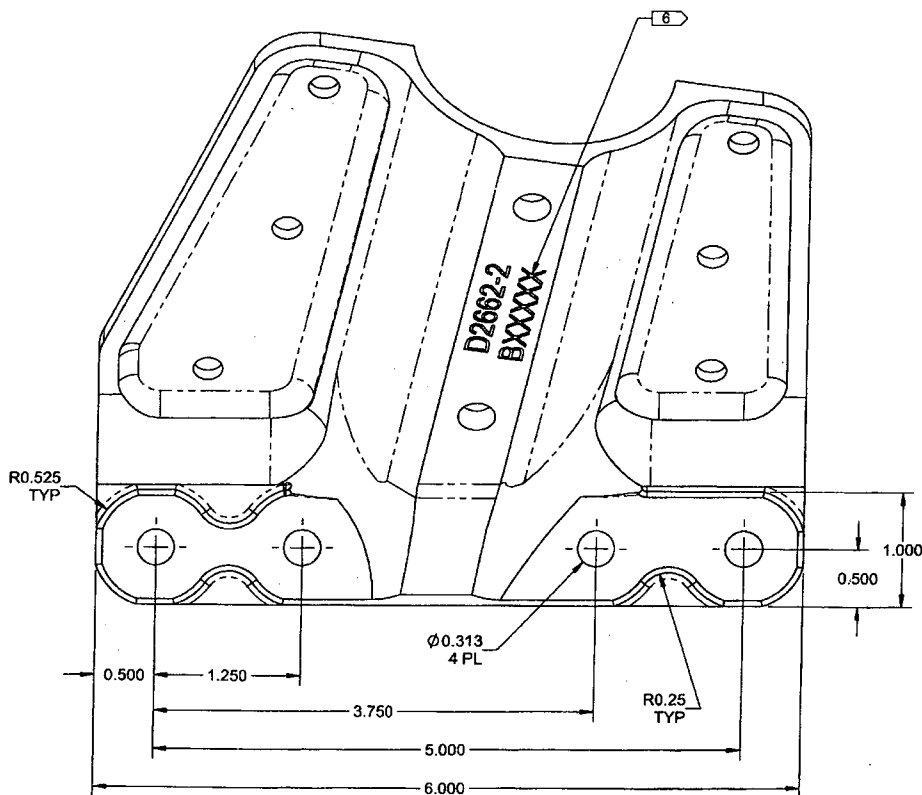
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

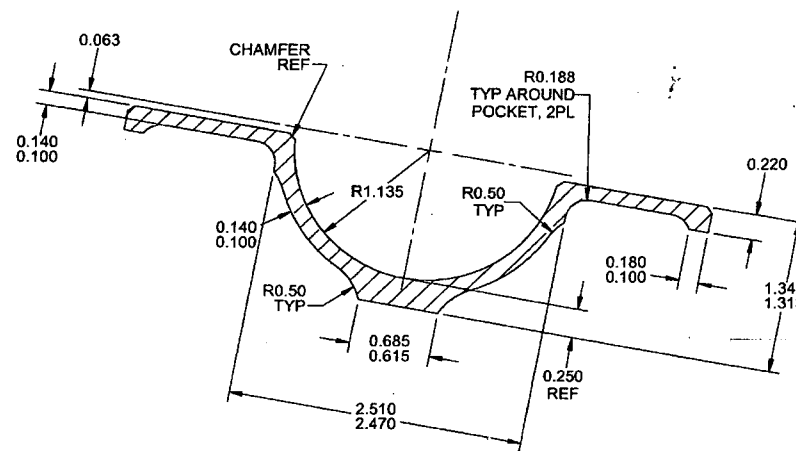
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW D-D
SCALE 1.5X B4-4
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

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